

Work Order ID 88966-1

88966-1

Page 1

May-17-13 8:45:08 AM

Item ID: D350-588-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Door Assembly

Start Date: 5/17/13

Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/17/13

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: W

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2445/D350-588

Rev D/D

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-588-041 CHG003

110

0.00

110

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 19381
Description: D2445 Baggage Door
Supplier: Delastek
Ship to Delastek (1) D0588-041 label
Certification of Conformity and process sheet from Delastek is required.

CL 13/05/17 ①

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May-17-13 8:45:08 AM

Item ID: D350-588-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Door Assembly

Start Date: 5/17/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 5/17/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

Receive & Inspect for Damage & Mat'l Certs

0.00

120

Packaging

Memo

0.00

Packaging

Ensure Certificate of Conformity & Process Sheet are attached

43/0/17 (1)

130

QC6- Inspect dimensions to drawing

0.00

130

QC

Memo

0.00

Quality Control

Inspect as per Dwg D2445.
Audit process sheet.

OAS
16
13/6/22

140

Small Fab

0.00

140

Small Fab

Memo

0.00

Small Fab

Assemble all of the above parts as per Dwg D350-588

13-06-03

1

Work Order ID 88966-1

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May-17-13 8:45:08 AM

Item ID: D350-588-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Door Assembly

Start Date: 5/17/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/17/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

NR1

QC: Date: SPC (Y/N): Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00				1			
150									
QC	Memo	0.00							
Quality Control		13.6.3							
155	Pick Kit	0.00				1X			
155									
Packaging	Memo	0.00							
Packaging									SD 13.6.3.
160	QC4- 100% Inspect kits for completeness	0.00				1			
160									
QC	Memo	0.00							
Quality Control		13.6.11							

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Item ID: D350-588-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Door Assembly

Start Date: 5/17/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 5/17/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>620</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

8 B/6/12 sf

MS 13-06-12

B06-12

Picklist Print

May-17-13 8:45:06 AM

Page 1

Work Order ID: 88966-1
Parent Item: D350-588-041
Parent Item Name: Aft Door Assembly

Start Date: 5/17/13
Start Qty: 1.00

Required Date: 5/17/13
Required Qty: 1.00

Comments: IPP P 04.02.04ReformatKJ/DS IPP Rev:Q as per DSI9414 DD
verified by:EC IPP Rev:R add pick kit DD 10.03.29 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN526C1032R7 Screw		Purchased	No			155	Each	74.0000	2	2		SP 13-6-3	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST346		74							
				123831		74							
AN526C832R8 Screw		Purchased	No			155	Each	340.0000	8	8		SP 13-6-3	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST345	125752	140							
				122814		8							
				123522		32							
				124552		100							
				ST516		200							
				125388		200							
AN526C832R9 Screw		Purchased	No			140	Each	295.0000	8	8		SP 13-6-3	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST345		95							
				124552		95							
				ST516		200							
				125388		200							
AN960JD10 Washer	NAS1149D0363J	Purchased	No			140	Each	0.0000	2	2		SP 13-6-3	
AN960JD10 Washer	NAS1149D0363J	Purchased	No			155	Each	0.0000	2	2		SP 13-6-3	

Picklist Print

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Page 2

Work Order ID: 88966-1
Parent Item: D350-588-041
Parent Item Name: Aft Door Assembly

Start Date: 5/17/13

Required Date: 5/17/13

Start Qty: 1.00

Required Qty: 1.00

D2143
Hinge Bracket

Manufactured No

140 Each 30.0000 1 1

Location

Loc Qty

Loc Code

ST005

30

92166

18

98391

12

13-06-03

D2144
Hinge Bracket

Manufactured No

140 Each 23.0000 1 1

Location

Loc Qty

Loc Code

ST005

23

92181

23

D2150
Packer Doubler, Hinge

Manufactured No

155 Each 14.0000

Location

Loc Qty

Loc Code

ST005

14

92182

14

D2151
Packer Doubler, Hinge

Manufactured No

155 Each 48.0000

Location

Loc Qty

Loc Code

ST005

48

92172

18

95852

30

D2153
Door Prop

Manufactured No

155 Each 28.0000

Location

Loc Qty

Loc Code

FG

5

85865

5

ST260

23

97385

23

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Shop Packet Print

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Work Order ID: 88966-1
Parent Item: D350-588-041
Parent Item Name: Aft Door Assembly

Start Date: 5/17/13

Required Date: 5/17/13

Start Qty: 1.00

Required Qty: 1.00

D2154
Stud Bracket

Manufactured No

155

Each

26.0000

Location

Loc Qty

Loc Code

ST006

26

82333

26

D2237
Striker Plate

Manufactured No

155

Each

17.0000

Location

Loc Qty

Loc Code

ST007

17

93697

10

98898

7

D2445P
AFT DOOR ASSEMBLY

Purchased No

110

Each

0.0000

*D2461
Neoprene "D" Seal
(D2461-0870) cut (1) at 87.00"
**** per kit****

Manufactured No

155

f

361.4939

7.25

7.25

Location

Loc Qty

Loc Code

ST415

361.493894

39782

6.5

55054

4

63880

14.8237

73644

113.702984

85225

222.46721

D2463

Seal
(D2463-0870) cut (1) at 87.00"
**** per kit****

Manufactured No

140

f

1,025.1303

7.25

7.25

Location

Loc Qty

Loc Code

ST403

1025.13028

72232

15.38

79478

0.43737

83542

0.04291

90297

31.02

95774

478.25

98335

500

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Work Order ID: 88966-1
Parent Item: D350-588-041
Parent Item Name: Aft Door Assembly

Start Date: 5/17/13

Required Date: 5/17/13

Start Qty: 1.00

Required Qty: 1.00

D2585
Mounting Channel

Manufactured No

140 Each 46.0000

2

2

~~13-06-03~~

Location

Loc Qty

Loc Code

ST012

46

73297

3

91960

1

95951

10

97294

20

97608

12

D2586

Door Latch

Manufactured No

140 Each 82.0000

2

2

~~13-06-03~~

Location

Loc Qty

Loc Code

FG

12

83893

10

95760

2

return2013

3

xxxxx

3

ST198A

67

95760

67

D2589

Keys, Key Chain, 350 Hinge

Manufactured No

155 Each 99.0000

1

1

~~13-06-03~~

Location

Loc Qty

Loc Code

ST012

99

58194

99

D2621

Latch Plate, 350 Spacepod

Manufactured No

140 Each 32.0000

2

2

~~13-06-03~~

Location

Loc Qty

Loc Code

FG

2

88616

2

ST014

30

88616

30

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Work Order ID: 88966-1

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 5/17/13

Required Date: 5/17/13

Start Qty: 1.00

Required Qty: 1.00

D2690-17

Cable

Manufactured No

155

Each

40.0000

Location

Loc Qty

Loc Code

ST016

40

100261

2

100752

10

85866

3

91824

4

92128

9

94470

4

95699

8

D2857-1

Hinge Bracket

Manufactured No

140

Each

29.0000

Location

Loc Qty

Loc Code

FG

5

82261

4

91914

1

ST019

24

91914

14

95859

10

D2857-2

Hinge Bracket

Manufactured No

140

Each

33.0000

Location

Loc Qty

Loc Code

FG

4

78904

4

ST019

13

95712

13

ST020

16

85806

1

92134

15

~~SPB-6-3~~
SPB-6-3

~~13-06-03~~
13-06-03

~~13-06-03~~
13-06-03

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Shop Packet Print

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Work Order ID: 88966-1
Parent Item: D350-588-041
Parent Item Name: Aft Door Assembly

Start Date: 5/17/13
Start Qty: 1.00

Required Date: 5/17/13
Required Qty: 1.00

D2858-1
Hinge Bracket

Manufactured No

Each 39.0000 1 1

Location	Loc Qty	Loc Code
FG	2	
77019	2	
ST019	37	
82337	1	
91826	15	
95701	21	

~~SP 13-06-03~~
SP 13-6-3

D2858-2
Hinge Bracket

Manufactured No

Each 42.0000 1 1

Location	Loc Qty	Loc Code
FG	2	
77020	2	
ST020	40	
89263	19	
95851	21	

~~SP 13-06-03~~
SP 13-6-3

FG-778150-550-ROL
7781 9oz Glass 50"x125yd
CUT ONE SQUARE FEET PER KIT

Purchased No

sf 1,137.1600 1 1

Location	Loc Qty	Loc Code
CA	1137.16	
123239	1137.16	

~~SP 13-06-03~~
SP 13-6-3

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Work Order ID: 88966-1
 Parent Item: D350-588-041
 Parent Item Name: Aft Door Assembly

Start Date: 5/17/13

Required Date: 5/17/13

Start Qty: 1.00

Required Qty: 1.00

MS20426AD3-4
 RIVET

Purchased No

155

Each

27,068.000

12

12

SP

SP

Location

Loc Qty

Loc Code

ST333	36	
123352	36	
ST334	8000	
123164	8000	
ST505	8000	
124814	8000	
ST509	11032	
124586	3032	12x
125578	8000	

MS20470AD4-5

Rivet, Universal Head

Purchased No

155

Each

2,719.0000

18

18

SP

SP

Location

Loc Qty

Loc Code

GA	398	
122452	398	
ST336	2321	
122452	821	15x
125654	1500	

MS21042L08

Nut

Purchased No

140

Each

4,709.0000

8

8

13-06-03

Location

Loc Qty

Loc Code

ST315	2709	
122141	3	
122452	9	
122814	500	
123900	2197	8
ST505	2000	
125445	2000	

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Work Order ID: 88966-1
 Parent Item: D350-588-041
 Parent Item Name: Aft Door Assembly

Start Date: 5/17/13

Required Date: 5/17/13

Start Qty: 1.00

Required Qty: 1.00

MS21042L08
 Nut

Purchased No

155

Each

4,709.0000

10

10

Location

Loc Qty

Loc Code

ST315

2709

122141

3

122452

9

122814

500

123900

2197

ST505

2000

125445

2000

★ MS21042L3
 Nut

Purchased No

140

Each

3,635.0000

2

2

Location

Loc Qty

Loc Code

FP001

3

122141

3

GA

18

122452

18

ST314

268

117885

32

119017

55

119075

138

123265

43

ST506

3346

123900

954

124291

2392

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Shop Packet Print

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Picklist Print

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Page 9

Work Order ID: 88966-1
 Parent Item: D350-588-041
 Parent Item Name: Aft Door Assembly
 MS21042L3
 Nut

Start Date: 5/17/13

Required Date: 5/17/13

Start Qty: 1.00

Required Qty: 1.00

Purchased No

155

Each

3,635.0000

4

Location

Loc Qty

Loc Code

FP001	3	
122141	3	
GA	18	
122452	18	
ST314	268	
117885	32	
119017	55	
119075	138	
123265	43	
ST506	3346	
123900	954	
124291	2392	

SP 13-6-3

MS27039-08-11
 Screw

Purchased No

155

Each

1,160.0000

2

Location

Loc Qty

Loc Code

ST307	660	
122441	100	
123352	500	
123900	60	
ST308	500	
125654	500	

SP 13-6-3

MS27039-1-15
 Screw

Purchased No

140

Each

943.0000

2

2

Location

Loc Qty

Loc Code

ST506	943	
124326	943	

SP 13-06-03

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Work Order ID: 88966-1
 Parent Item: D350-588-041
 Parent Item Name: Aft Door Assembly

Start Date: 5/17/13
 Start Qty: 1.00

Required Date: 5/17/13
 Required Qty: 1.00

NAS1149DN832J Purchased No

140 Each 3,231.0000 8 8

13-06-03

WASHER

Location Loc Qty Loc Code

ST293 3057
 123348 60
 123352 200
 123603 400
 123900 12
 124555 400
 125268 1985
 ST509 174
 124093 174

NAS1149DN832J Purchased No

155 Each 3,231.0000 16 16

WASHER

Location Loc Qty Loc Code

ST293 3057
 123348 60
 123352 200
 123603 400
 123900 12
 124555 400
 125268 1985
 ST509 174
 124093 174

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Shop Packet Print

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO19381**

Purchase Order Date 3/20/2013

PO Print Date 5/17/2013

Page Number 1 of 1

Order From :

VU-DEL003

DELASTEK INC

2699 5E AVENUE, LOCAL C.P 10100

GRAND-MERE, QC G9T 5K7
CA

Contact Name

Vendor Phone

819 533 5788

Vendor Fax

819 533 3494

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

USD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2445P	AFT DOOR ASSEMBLY	3/27/2013 Yes	1.00 Each	FedEx PI collect	\$580.0000	\$580.00

Special Inst: AS PER DWG D2445 REV. D
B88966-1

PO Total:

\$580.00

Change Nbr: 2

Change Date: 5/17/2013

CL
No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required - YES NO



DELASTEK Inc.
2699 5e Avenue
Local 14, C.P. 10100
Grand-Mère, Québec G9T 5K7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP

CERTIFICATE OF COMPLIANCE

Invoice No.	47966
Customer No.	DART US

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200

Contact : Linda Lacelle

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200

Contact : Linda Lacelle



Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
07-05-2013	20-03-2013	23195	Chantal Lavoie	19381	Net 30 days USA
Ship Via	F.O.B.	Salesperson	GST/PST		
FEDEX P1 Collect	Point de départ	Mathieu Doucet, ext.690			
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC134-0013	Line 1 D350-588-041 Aft Baggage Door (D2445) U of M: Chaque Drawing N° : D2445 Rév.: D Serial # 49220 8/13/15/22 <div style="border: 1px solid black; border-radius: 50%; width: 80px; height: 40px; display: flex; align-items: center; justify-content: center;"> <div>Lot# 49220</div> </div>	

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request

Accepted by:








Quality department

AQ-357



☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.















Feuille de Procédé

Client: DART US DART AEROSPACE		Nom Dessin: N° D2445, AFT BAGGAGE DOOR	
Numéro Job: 49220		Numéro DKC134-0013	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
	Date: <u>07/02/13</u> Sceau: 		
6.0	GEL COAT	Application du Gel Coat	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire l'application du Gelcoat selon IG 0019			
	Date: <u>07/02/13</u> Sceau: 		
7.0	AAC1885	Tissu à délaminer Release ply B	
Comment Qty.: 1.52 VERGE(s)/Unit Total : 1.52 VERGE(s)		# de Lot: <u>N/A</u>	
Tissu à délaminer Release ply B			
8.0	AAC1887	Wrightlon 5200 Bleu P3	
Comment Qty.: 3.33 VERGE(s)/Unit Total : 3.33 VERGE(s)		# de Lot: <u>N/A</u>	
Wrightlon 5200 Bleu P3			
9.0	AC0885	Feutre de drainage N° Airweave N 10	
Comment Qty.: 2.78 VERGE(s)/Unit Total : 2.78 VERGE(s)			
10.0	AC0943	Stretchlon 200 poche à vide Vert	
Comment Qty.: 2.00 PIED(s)/Unit Total : 2.00 PIED(s)			
11.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish	
Comment Qty.: 2.0 VERGE(s)/Unit Total : 2.0 VERGE(s)		N° de Lot: <u>39576-1</u>	
9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish			
12.0	AMB0511	N° TG-13-U, Fiberglass 13 oz	
Comment Qty.: 0.33 VERGE(s)/Unit Total : 0.33 VERGE(s)		N° de Lot: <u>1-36302-1</u>	
N° TG-13-U, Fiberglass 13 oz			
13.0	AC0886	Ruban à gommer jaune #: T/AT-200Y	
Comment Qty.: 1.2500 ROULEAU(s)/Unit Total : 1.2500 ROULEAU(s)			
14.0	PREP-GENERAL	Préparation du matériel	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Tailler le matériel, selon les différents patrons de découpe comme suit:			
4 plis de tissus de 9.7 oz.			
1 pli de 13 oz. pour tout le contour de la pièce par 5" de large.			
3 fois le sac à vide Stretchlon 200.			
3 fois le film perforé P-3			
3 fois le feutre de drainage			
2 fois le tissu à délaminer (non nécessaire lors du bagging du core).			
Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.			

Date: Mercredi, 2013-02-06 14:45:13

Utilisateur: Stéphane Lessard









Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro Job:	49220	Numéro DKC134-0013
Numéro Job:		
# Séq.:	Machine ou Opération:	Description :
	Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en les superposant les uns sur les autres.	
	Date: <u>1.8/12/13</u> Sceau: 	
15.0	AMB0286	Catalyst N° DDM-9
Comment Qty.:	0.0130 GALLON(s)/Unit	Total : 0.0130 GALLON(s)
	Catalyst N° DDM-9	N° de Lot: <u>1-27829-1</u>
16.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
Comment Qty.:	0.360 KILOGRAMME(s)/Unit	Total : 0.360 KILOGRAMME(s)
	Résine (411B7530) 411-350 promo. 75min.	N° de Lot: <u>1-39253-1</u>
17.0	PREP-GENERAL	Préparation du matériel
		
Comment Setup:	0.00Hrs/ Run: 0.0000Min	Total Run : 0.0000Hrs
	Faire la préparation de la résine selon les quantité requises, mix ratio 1.5% de catalyst N° DDM-9 par quantité de résine N° 411-350.	
	Date: <u>8/2/13</u> Sceau: 	
18.0	LAMINAGE	Faire le laminage
		
Comment Setup:	0.00Hrs/ Run: 0.0000Min	Total Run : 0.0000Hrs
	À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8036 et ensuite imbiber un plis de tissu 9.7 oz.	
	Recommencer l'opération pour le deuxième pli.	
	Date: <u>8/2/13</u> Sceau: 	
19.0	BAGGING	Faire le bagging sur la pièce
		
Comment Setup:	0.00Hrs/ Run: 0.0000Min	Total Run : 0.0000Hrs
	Faire la poche à vide selon IG 0012.	
	Laisser sécher pendant 4 heures minimum.	
	Heure Curing début: <u>3:30</u>	Heure Curing Fin: <u>8:00</u>
	Date: <u>8/2/13</u> Sceau: 	

Date: Mercredi, 2013-02-06 14:45:13

Utilisateur: Stéphane Lessard








Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	N° D2445, AFT BAGGAGE DOOR
Numéro Job:	49220	Numéro DKC134-0013	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
20.0	AMB0286	Catalyst N° DDM-9	
Comment Qty.: 0.0042 GALLON(s)/Unit Total: 0.0042 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>			
21.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Comment Qty.: 0.120 KILOGRAMME(s)/Unit Total: 0.120 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-39253-1</u>			
22.0	PREP-GENERAL	Préparation du matériel	
 			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire la préparation de la résine selon les quantités requise, mix ratio 1.5% de catalyst N° DDM-9 par quantité de résine N° 411-350, Imbiber toutes les surfaces du Foam Core selon IG0105. Date: <u>12/2/13</u> Sceau: 			
23.0	AAC1611	Polybond B46F	
Comment Qty.: 0.045 KIT(s)/Unit Total: 0.045 KIT(s) Polybond B46F N° de Lot: <u>1-39139-1</u>			
24.0	DKC134-0029	Foam Core N° D2445-101 (Pour AFT Baggage Door)	
Comment Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s) Foam Core N° D2445-101 (Pour AFT Baggage Door) N° de Job: <u>48810</u>			
25.0	ASSEMBLAGE	Assemblage mécanique	
 			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Assembler le DKC134-0029 selon IG 0033 Date: <u>09-04-13</u> Sceau: <u>4433MM 4440CT</u>			
26.0	BAGGING	Faire le bagging sur la pièce	
 			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire la poche à vide selon IG 0012 Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond. Heure début Curing: <u>11:25</u> Heure Fin Curing: <u>12:30</u> Date: <u>9/04/13</u> Sceau: <u>4433MM 4440CT</u>			

Date: Mercredi, 2013-02-06 14:45:13

Utilisateur: Stéphane Lessard











Feuille de Procédé

Client:	DART US DART AEROSPACE		Nom Dessin:	N° D2445, AFT BAGGAGE DOOR	
Numéro Job:	49220		Numéro DKC	134-0013	
Numéro Job:					
# Séq.:	Machine ou Opération:	Description :			
27.0	AMB0286	Catalyst N° DDM-9			
Comment Qty.: 0.1360 GALLON(s)/Unit Total : 0.1360 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>					
28.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.			
Comment Qty.: 0.360 KILOGRAMME(s)/Unit Total : 0.360 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-40544-1</u>					
29.0	PREP-GENERAL	Préparation du matériel			
					
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs					
Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% de catalyst N° DDM-9 par quantité de résine N° 411-350.					
Date: <u>11/04/13</u> Sceau: <u>4440 CJ 4432 GB</u>					
30.0	LAMINAGE	Faire le laminage			
					
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs					
Faire le laminage d'un pli de 9.7 oz.					
Faire le laminage du plis de tissu 13 oz. tout le tour de la porte en prenant bien soin que les deux bandes allant dans le coin droit en bas se superposent					
Faire le laminage du dernier pli de 9.7 oz.					
Date: <u>11/04/13</u> Sceau: <u>4440 CJ 4432 GB</u>					
31.0	BAGGING	Faire le bagging sur la pièce			
					
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs					
Faire la poche à vide selon IG 0012					
Laisser sécher pendant 4 heures minimum.					
Heure Curing Début: <u>3:00</u> Heure Curing Fin: <u>8 hrs</u>					
Date: <u>11/04/13</u> Sceau: <u>4440 CJ 4432 GB</u>					








Date: Mercredi, 2013-02-06 14:45:13

Utilisateur: Stéphane Lessard

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	N° D2445, AFT BAGGAGE DOOR
Numéro Job:	49220	Numéro DKC134-0013	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
32.0	DÉMOULAGE	Démoulage de la pièce	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Démouler la pièce en faisant bien attention aux coins & Edges.			
Date: <u>12/04/13</u> Sceau: <u>4432 G.B.</u>			
33.0	TRIMAGE	Trimage	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
À l'aide du gabarit N°DT 8619 trimer la pièce en utilisant un router muni d'un couteau 1/4" et d'un " Bushing " 1/16" de mur.			
Percer les " Latch " et les trous de penture selon le dessin N° D2445.			
Date: <u>12/04/13</u> Sceau: <u>4432 G.B.</u>			
34.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler	
Comment Qty.: 0.014 GALLON(s)/Unit Total : 0.014 GALLON(s)			
N° P-15-3, Adtech Micro Ultra Filler # de Lot: <u>1-40372-1</u>			
35.0	FINITION	Finition Générale	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire les réparations de finition s'il y a lieu à l'aide du "Filler" P15-3.			
Date: <u>12/04/13</u> Sceau: <u>4432 G.B.</u>			
36.0	AAC1021	Dupont Primer N° 7704S	
Comment Qty.: 0.0280 UNITE(s)/Unit Total : 0.0280 UNITE(s)			
Dupont Primer N° 7704S N° de Lot: <u>1-37302-1</u>			
37.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase	
Comment Qty.: 0.0280 UNITE(s)/Unit Total : 0.0280 UNITE(s)			
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: <u>1-38821-1</u>			
38.0	PRIMER	Application primer	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire la préparation et l'application du primer batisseur selon I.G. 0008			
Date: <u>16 104/13</u> Sceau:  # de fiche de mélange: <u>N/A</u>			








Feuille de Procédé

Client: DART US DART AEROSPACE		Nom Dessin: N° D2445, AFT BAGGAGE DOOR	
Numéro Job: 49220		Numéro DKC134-0013	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
39.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler	
Comment Qty.: 0.014 GALLON(s)/Unit Total : 0.014 GALLON(s) N° P-15-3, Adtech Micro Ultra Filler # de Lot: <u>1-40372-1</u>			
40.0	FINITION	Finition Générale	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire les réparations de finition s'il y a lieu à l'aide du "Filler" P15-3. Date: <u>23-04-13</u> Sceau: <u>4435/25</u>			
41.0	AAC1605	Label N° D0588-041	
Comment Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) Label N° D0588-041 N° de Lot: <u>N/A</u>			
42.0	AAC1609	Surface Veil	
Comment Qty.: 0.07 VERGE(s)/Unit Total : 0.07 VERGE(s) Surface Veil N° de Lot: <u>N/A</u>			
43.0	AAC1220	Résine Mia-Poxy 100	
Comment Qty.: 0.007 GALLON(s)/Unit Total : 0.007 GALLON(s) Résine Mia-Poxy 100 N° de Lot: <u>1-30095-4</u>			
44.0	AAC1221	Durcisseur 95 Pour Résine Mia-Poxy	
Comment Qty.: 0.007 QUART(s)/Unit Total : 0.007 QUART(s) Durcisseur 95 Pour Résine Mia-Poxy N° de Lot: <u>1-34505-1</u>			
45.0	ASSEMBLAGE	Assemblage mécanique	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Coller le label N° D0588-041 selon IG 0111. Date: <u>22/04/13</u> Sceau: <u>4440 C5</u>			
46.0	AAC1021	Dupont Primer N° 7704S	
Comment Qty.: 0.0280 UNITE(s)/Unit Total : 0.0280 UNITE(s) Dupont Primer N° 7704S N° de Lot: <u>1-37302-1</u>			
47.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase	
Comment Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: <u>1-37302-1</u>			
48.0	PRIMER	Application primer	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire la préparation et l'application du primer final selon I.G. 0008			

Date: Mercredi, 2013-02-06 14:45:13

Utilisateur: Stéphane Lessard

Feuille de Procédé

Client: DART US DART AEROSPACE		Nom Dessin: N° D2445, AFT BAGGAGE DOOR	
Numéro Job: 49220		Numéro DKC134-0013	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
	Date: <u>24-04-2013</u> Sceau: 	# de fiche de mélange: <u>N/A</u>	
49.0	INSPEC FINAL	Inspection finale	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire l'inspection selon le dessin N° D2445.			
Date: <u>29-4-13</u> Sceau: 			
50.0	EMBAL / ENTREPO	Emballage & Entreposage	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire l'emballage des pièces selon IG 0057			
Date: <u>30/04/13</u> Sceau: <u>SM</u>			

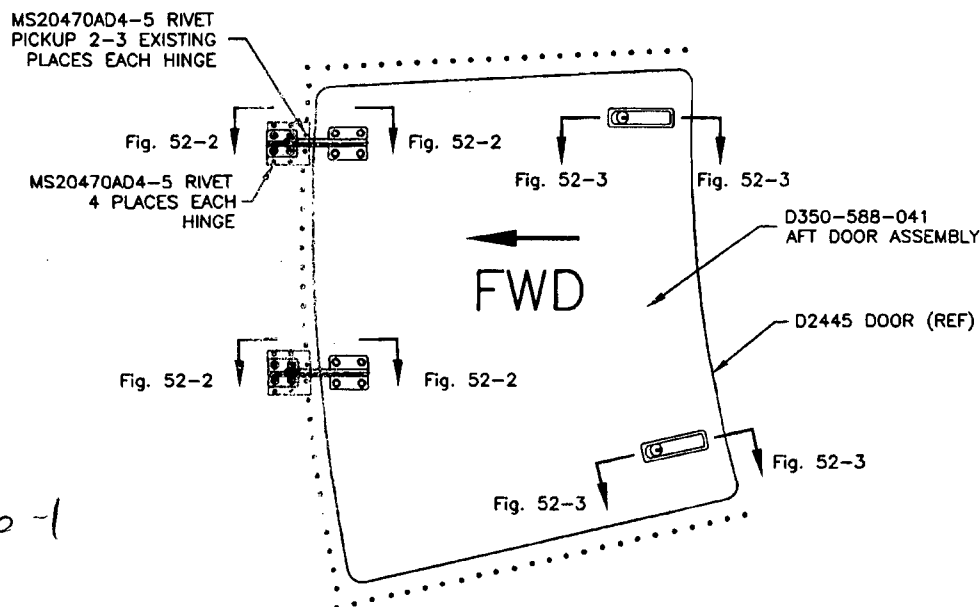


Figure 52-1: Baggage Door Outside View

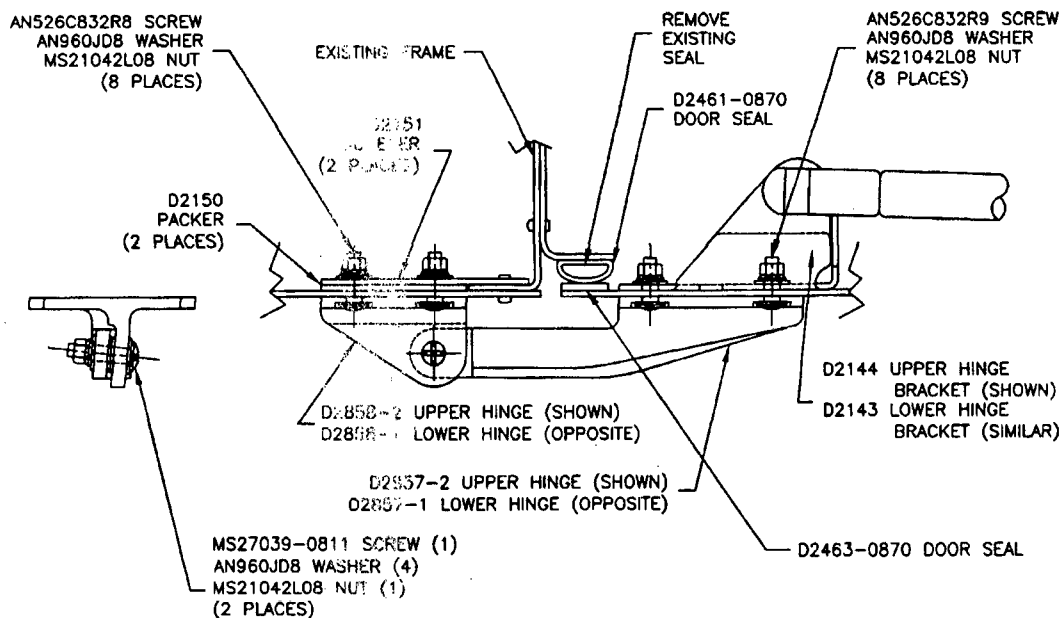


Figure 52-2: Hinge Detail

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52-00-00

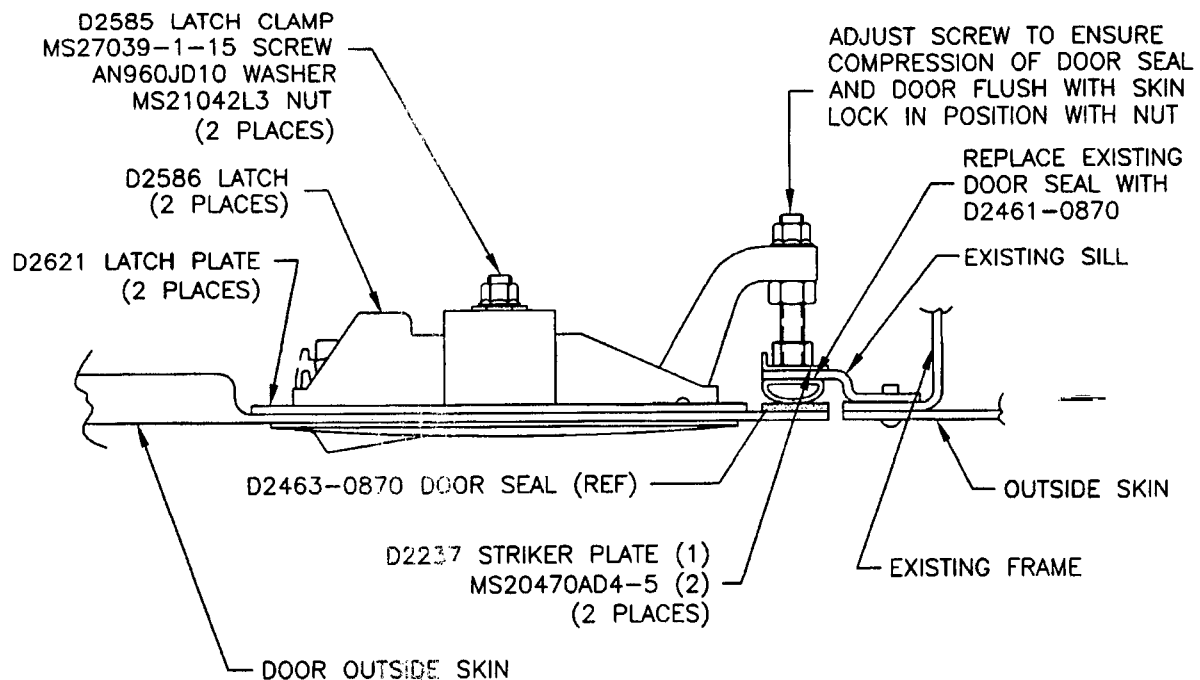


Figure 52-3: Latch Section

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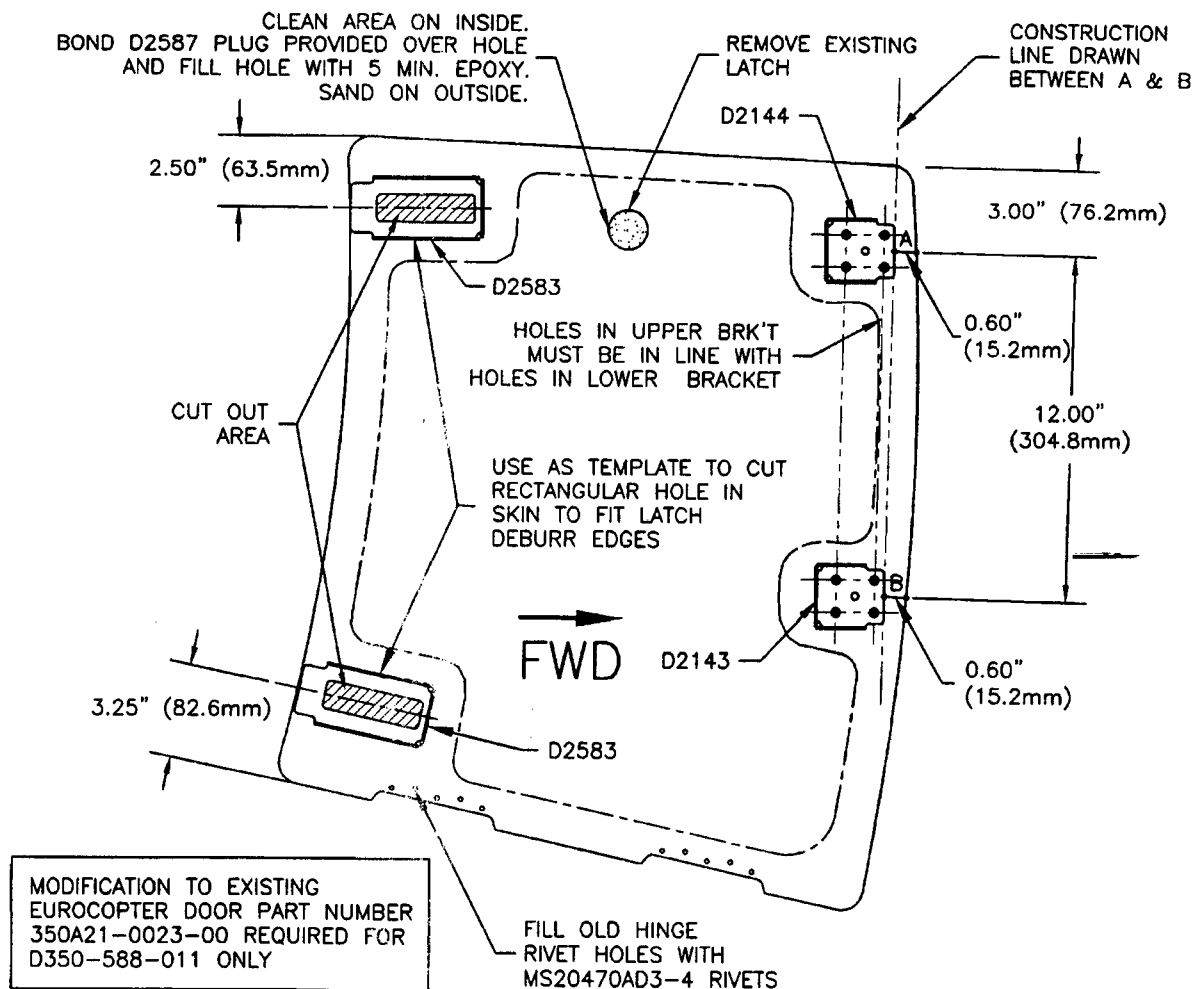


Figure 52-5: Baggage Door Inside View

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52-00-00

3.3 WEIGHT AND BALANCE**REFERENCE ONLY**

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

3.4 PARTS LISTS

588-041	588-011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	1/2" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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Revision: D

Date: 02.01.17